

# Work Order ID 87014

Monday, July 09, 2012 3:50:32 PM

**\*87014\***

Page 1

Item ID: D350-636-013

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/07/10* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

F

D3492

C

IIN-D350-636

I

100

0.00

**\*100\***

DOCUMENT CONTROL

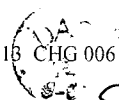
DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-013 CHG 006



*5/17/06*

*df for MLJ 12-8-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 87014**

Monday, July 09, 2012 3:50:32 PM

**\*87014\***

Page 2

Item ID: D350-636-013

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 &amp; DT8864A for first side only DT8864B for second side (detail B)

7- Clecko DT8864B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

7 CF 12-7-26

12/08/01

W/O:		WORK ORDER CHANGES					
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**Work Order ID 87014**

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**\*87014\***

Page 3

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: M122130

12-Grind welds flush as per Dwg D2750

3 BE 12/07/26  
12/08/01

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
16  
8-812/08/01

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

DAS  
16  
8-812/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*87014\***

Page 5

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00

**\*160\***

Skidtubes

Memo

Skidtubes

Skidtubes

**Memo**

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 122130

exp. date: 13103/14

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 10)

A/R Aluminum Rod

batch: M122399

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

BB

12/08/01

SAD

12-08-01

BE 12/08/02

BB

12/08/02

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 87014****\*87014\***

Page 6

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Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 76 12-8-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*87014\***

Page 7

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Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1h00  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 1h30

mr21 481 ✓

1 & @ 7/2/08/08.

210

QC3- Inspect Part Finish

0.00

**\*210\***

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1h11 d 11 12/08/15

220

HandFinishing

0.00

**\*220\***

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

1h11 d 11 12/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*87014\***

Page 8

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Item Name: Skidtube LH

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Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

0.00

**\*230\***

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: 10/14

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11122443

EXP DATE: 12163

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 1412165

5-Coat all exposed fasteners with "LPS Procyon" batch: 1114596

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

DAS  
16  
8-83  
100/15  
SMB  
10-8-15

164 4 11 120815

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 87014

Monday, July 09, 2012 3:50:32 PM

**\*87014\***

Page 9

Item ID: D350-636-013

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

*Wk/2osp*

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

*16 9-21*

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-013

*Rev2*

*12/8/21sp*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 87014**

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**\*87014\***

Page 10

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

MCS 12/08/23  
MCS 12/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Monday, July 09, 2012 3:50:31 PM

Page 1

12

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H02.09.25Rearranged procedure steps KJ  
 IPP rev I 06.03.30 Per rev. D dwg EC  
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec IPP Rev:L 10.06.22 revise seq110  
 DD verf:EC IPP Rev:M 10.10.01 as per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS4-1032-225

Purchased

No

230

Each

2,888.0000

38

38

Insert

sl 12/08/15

Location

Loc Qty

Loc Code

FP-B

2445

122290

2445

ST281

420

X38

108696

146

110768

62

118386

55

118966

68

121269

89

ST282

23

120410

10

120451

13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, July 09, 2012 3:50:31 PM

Page 2

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 1,611.0000 34 34 12/08/15  
Bolt

Location	Loc Qty	Loc Code
FP001	7	
115835	7	
ST350	1604	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	28	
121255	469	
121444	34	
121708	500	
<u>122141</u>	<u>500</u>	

AN3C6A Purchased No 230 Each 285.0000 4 X34 12/08/15  
BOLT

Location	Loc Qty	Loc Code
FP001	1	
111982	1	
ST351	284	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
<u>120693</u>	<u>118</u>	
121682	74	

Monday, July 09, 2012 3:50:31 PM

Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 104.0000 4 *4 12/08/15*

BOLT

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST343	102	
121013	11	<i>M 122491</i>
121440	41	<i>x4</i>
122204	50	

*8* AN8C21A Purchased No 250 Each 77.0000 2 *2 sf*

BOLT

Location	Loc Qty	Loc Code
ST343	77	
118758	3	
121275	24	
122204	50	<i>2</i>

AN8C35A Purchased No 230 Each 61.0000 1 *1 12/08/15*

BOLT

Location	Loc Qty	Loc Code
FP002	60	
115960	1	
118286	9	
121275	50	
ST346	1	<i>x1</i>
114442	0	
115188	0	
115960	1	

AN960C10L washer *x* NAS1149C0332R Purchased No 230 Each 21.0000 38 *(x38) 38 12/08/15*

Location	Loc Qty	Loc Code
ST	21	
107534	21	

Monday, July 09, 2012 3:50:31 PM

Shop Packet Print

Page 3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, July 09, 2012 3:50:31 PM

Page 4

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each 33.0000

1

①

1

CF 12-1-26

Extrusion Bent

## Location

## Loc Qty

## Loc Code

LG	33	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
86330	17	

D2739

Manufactured No

160 Each 14.0000

1

SAD

6-08-07

350 I Beam

## Location

## Loc Qty

## Loc Code

LG	14	
72155	1	
81508	1	
83448	2	
83548	1	
85486	5	
86615	4	

B 88013

①

12/8/00 sf

D2741

Manufactured No

250 Each 34.0000

1

1

Blade, 350 Skidtube

## Location

## Loc Qty

## Loc Code

ST	-10	
ST466	44	
71856	1	
83135	33	

Monday, July 09, 2012 3:50:31 PM

Shop Packet Print

Page 4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 09, 2012 3:50:31 PM

Page 5

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

220

Each

152.0000

8

8

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

78

81965

23

83262

55

LG001

74

67766

4

68251

3

73403

64

74445

1

79517

2

BE 6/08/02  
B 85459 x8

D2744

Manufactured No

160

Each

60.0000

1

1

Cap

Location

Loc Qty

Loc Code

LG002

60

62715

1

83412

21

85506

38

BE 12/07/26

D2745

Manufactured No

230

Each

258.0000

8

8

Bushing

Location

Loc Qty

Loc Code

FP

206

79518

6

85416

200

FP001

52

69529

1

76142

1

83260

50

91 11/03/22

x8

Monday, July 09, 2012 3:50:31 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, July 09, 2012 3:50:31 PM

Page 6

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041  
Blade Fitting Assembly, LH

Manufactured No

230 Each 29.0000

1 11 12/08/15

Location	Loc Qty	Loc Code
FP001	12	
85807	12	
FP002	17	
83407	10	
85733	7	

X1

D3490-1  
Cross Bolt Spacer

Manufactured No

160 Each 79.0000

4 4

BE 12/08/02

Location	Loc Qty	Loc Code
LG	68	
81976	2	
85419	66	
LG001	11	
62450	2	
74875	4	
77042	3	
83269	2	

4

D3490-5  
Cross Bolt Spacer

Manufactured No

160 Each 31.0000

4 4

BE 12/08/02

Location	Loc Qty	Loc Code
LG001	31	
83373	31	

4

D3492-1  
Plug

Manufactured No

230 Each 205.0000

8 8

11 11 08/15

Location	Loc Qty	Loc Code
FP002	198	
69531	8	
74444	2	
76235	4	
83259	184	
FP-A	7	
83098	7	

B87662

X8

Monday, July 09, 2012 3:50:32 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, July 09, 2012 3:50:32 PM

Page 7

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-5 Plug Manufactured No 230 Each 135.0000

8

yl 8 12/08/15

Location

Loc Qty

Loc Code

fpa

135

83100

34

83530

101

x 8

D3493-1

Washer

Manufactured No

110 Each 97.0000

2

2

Location

Loc Qty

Loc Code

ST050

97

77573

1

82023

2

83097

94

D3535-25

Wearshoe

Manufactured No

230 Each 32.0000

1

yl 1 12/08/15

Location

Loc Qty

Loc Code

FP001

32

62233

1

81357

1

83387

17

83899

13

x 1

D3536-25

Gasket

Manufactured No

230 Each 22.0000

1

yl 1 12/08/15

Location

Loc Qty

Loc Code

FP

22

83391

6

83900

16

x 1

Monday, July 09, 2012 3:50:32 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, July 09, 2012 3:50:32 PM

Page 8

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1  
Wearpad

Manufactured No

230 Each 112.0000

3 ML <sup>3</sup> 11/08/15

Location

Loc Qty

Loc Code

FP002

112

81362

3

83254

1

83255

3

83256

20

85457

37

85458

48

X3

D3631-1  
Washer

Manufactured No

230 Each 283.0000

8 ML <sup>8</sup> 11/08/15

Location

Loc Qty

Loc Code

FG

268

81874

2

83588

266

X8

ST072

15

68062

2

75548

13

D3791-1  
Wearplate

Manufactured No

230 Each 26.0000

1 ML <sup>1</sup> 12/08/15

Location

Loc Qty

Loc Code

FP002

26

62239

2

83392

12

83902

12

X1

D3793-1  
Wearshoe

Manufactured No

230 Each 26.0000

1 ML <sup>1</sup> 12/08/15

Location

Loc Qty

Loc Code

FP001

26

82171

2

83393

11

83903

13

X1

Monday, July 09, 2012 3:50:32 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 09, 2012 3:50:32 PM

Page 9

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No 230 Each 28.0000  
Wearshoe

1 ML 12/08/15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	28	
83394	16	
<u>83901</u>	12	

D3794-1 Manufactured No 230 Each 24.0000  
Gasket

1 ML 12/08/15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	4	
82167	4	
FP002	20	
<u>83395</u>	20	

D3794-3 Manufactured No 230 Each 45.0000  
Gasket

1 ML 12/08/15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	19	
<u>83396</u>	19	
FP002	26	
74530	2	
86243	24	

MS21043-6 Purchased No 230 Each 586.0000  
NUT

4 ML 12/08/15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693	20	
ST301	566	
117887	2	
118384	64	
<u>120308</u>	500	

74

Monday, July 09, 2012 3:50:32 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 09, 2012 3:50:32 PM

Page 10

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

94.0000

1

NUT

## Location

## Loc Qty

## Loc Code

304

39

121185

22

121349

17

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST321

50

122141

50

MS21083C8

Purchased

No

250

Each

94.0000

2

NUT

## Location

## Loc Qty

## Loc Code

304

39

121185

22

121349

17

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST321

50

122141

50

Monday, July 09, 2012 3:50:32 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 09, 2012 3:50:32 PM

Page 11

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

250.0000

1

*HL*

1

*12/08/15*

WASHER

Location

Loc Qty

Loc Code

ST297

250

*114915*

250

NAS1149D0863J

Purchased

No

250

Each

221.0000

2

2

*HL*

WASHER

Location

Loc Qty

Loc Code

ST298

221

118078

34

119307

1

120308

86

121556

100

NAS1515H3L

Purchased

No

230

Each

311.0000

4

*HL*

4

*12/08/15*

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

271

118686

3

120360

11

121556

57

122151

200

NAS1611-005

Purchased

No

230

Each

140.0000

8

8

*HL*

*12/08/15*

O-RING

Location

Loc Qty

Loc Code

FP001

140

106099

18

114220

46

119438

36

121415

40

*x 8*

Monday, July 09, 2012 3:50:32 PM

Shop Packet Print

Page 11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, July 09, 2012 3:50:32 PM

Page 12

Work Order ID: 87014

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

416.0000

8

8

O-RING

12/08/15

## Location

## Loc Qty

## Loc Code

FP001

416

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121584

2

121723

39

122151

300

XG

Monday, July 09, 2012 3:50:32 PM

Shop Packet Print

Page 12

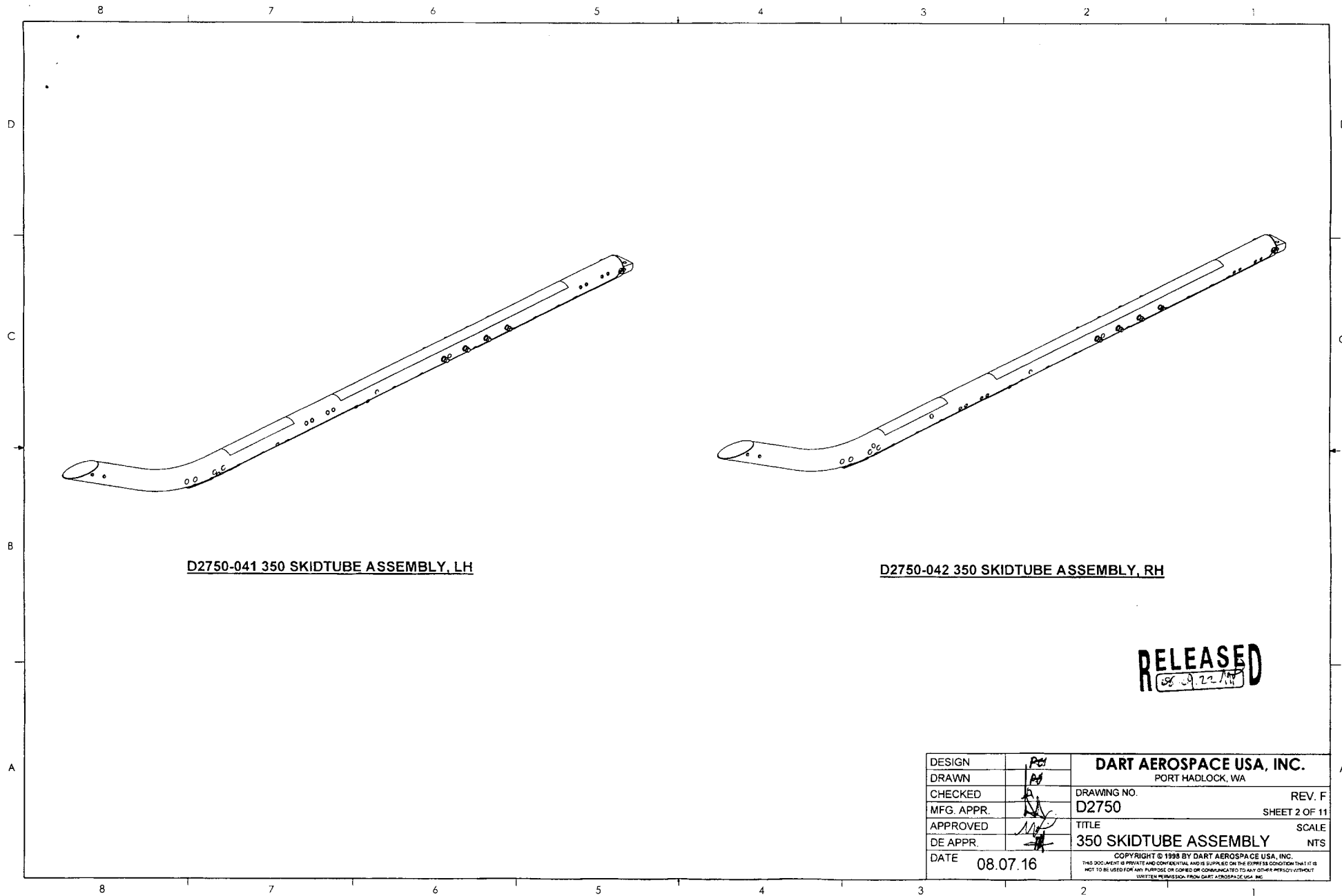
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
88.02.14

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AB	PORT HADLOCK, WA	
CHECKED	AB	DRAWING NO. D2750	REV. F
MFG. APPR.	AB	SHEET 2 OF 11	
APPROVED	AB	TITLE	SCALE
DE APPR.	AB	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA			
DRAWING NO. <b>D2750</b>		REV. F SHEET 1 OF 11	
TITLE <b>350 SKIDTUBE ASSEMBLY</b>		SCALE NTS	
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**Dart Aerospace Ltd**

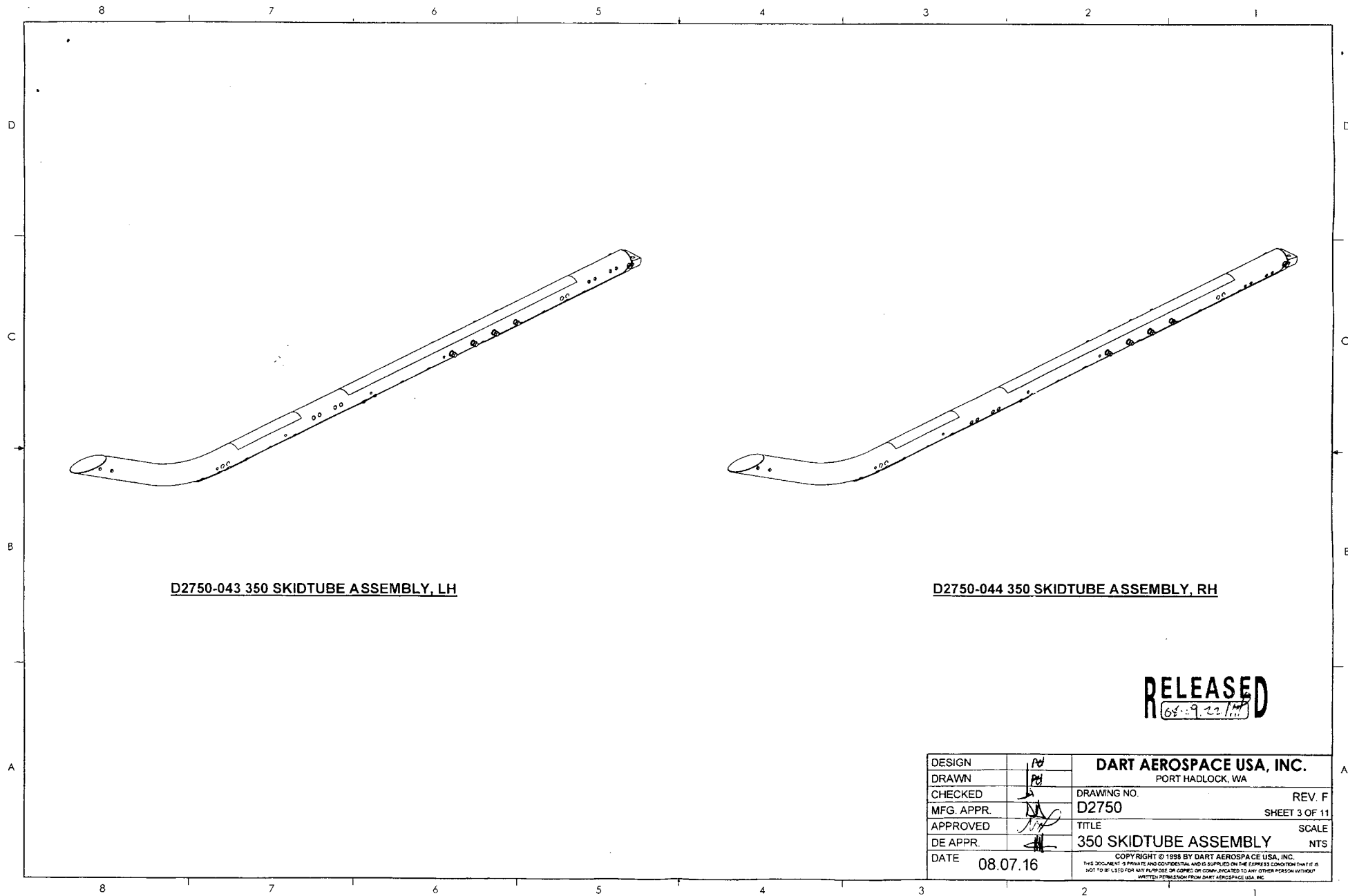
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/111

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PC	PORT HADLOCK, WA	
CHECKED	JF	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	JF	SHEET 3 OF 11	
APPROVED	JF	TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
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DATE	08.07.16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

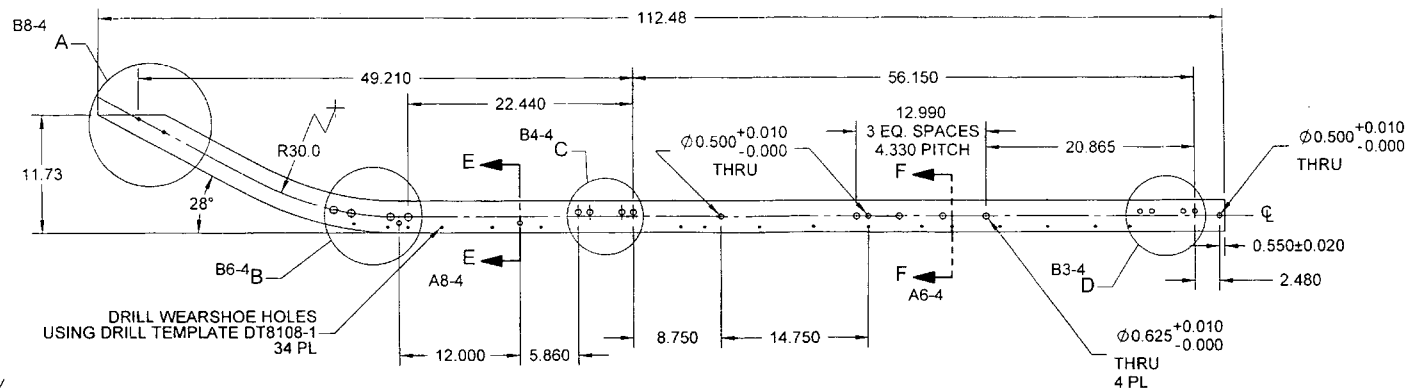
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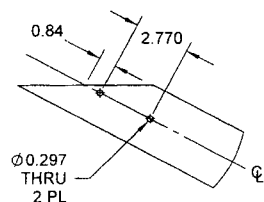
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

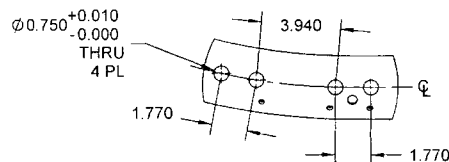




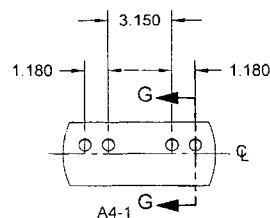
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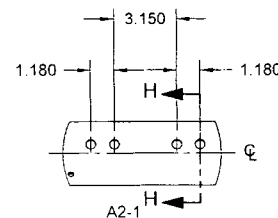
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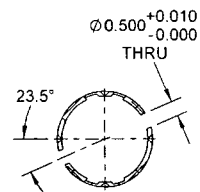
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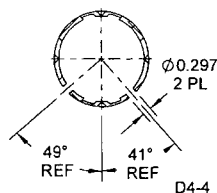
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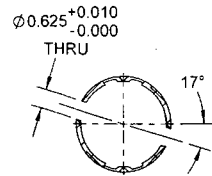
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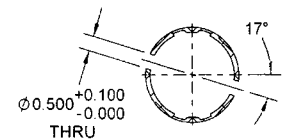
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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DESIGN	IPB	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	IPB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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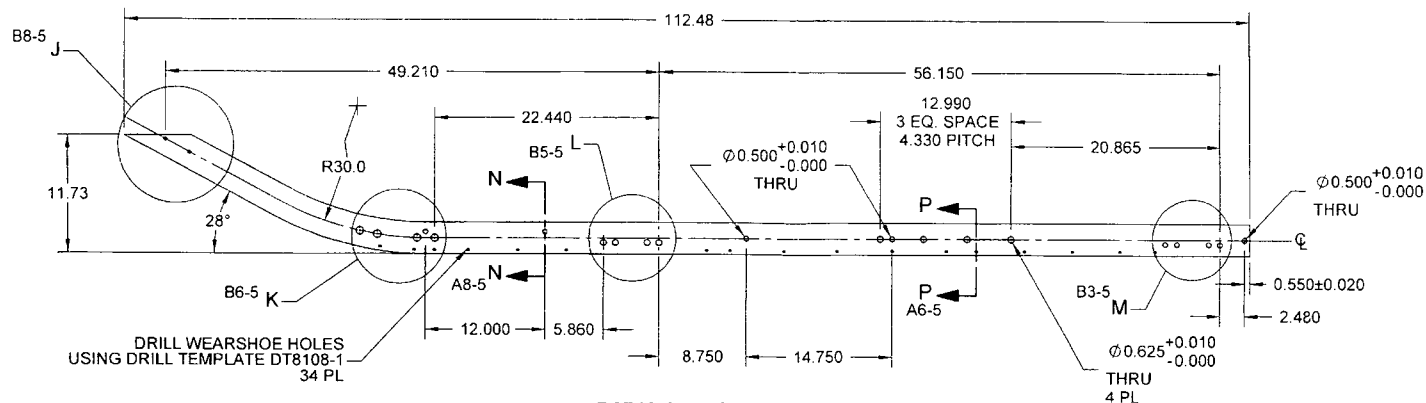
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

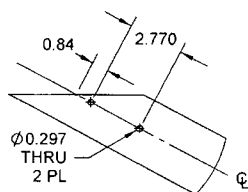
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

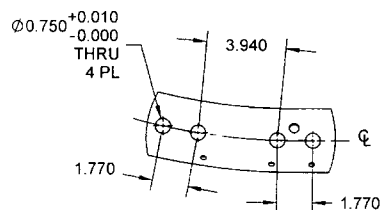
**NOTE:** Date & initial all entries



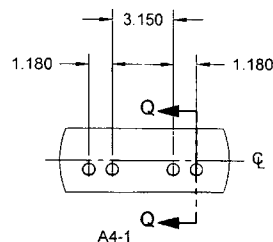
### D2750-2 RH SKIDTUBE



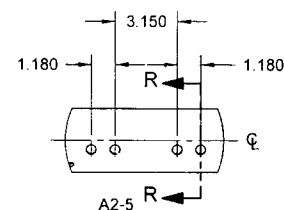
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SCALE 2X



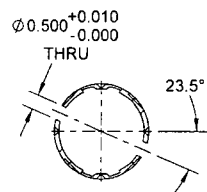
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SCALE 2X



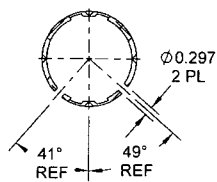
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SCALE 2X



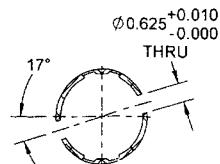
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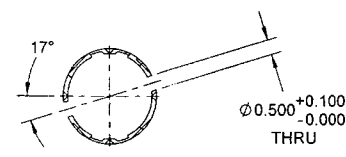
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

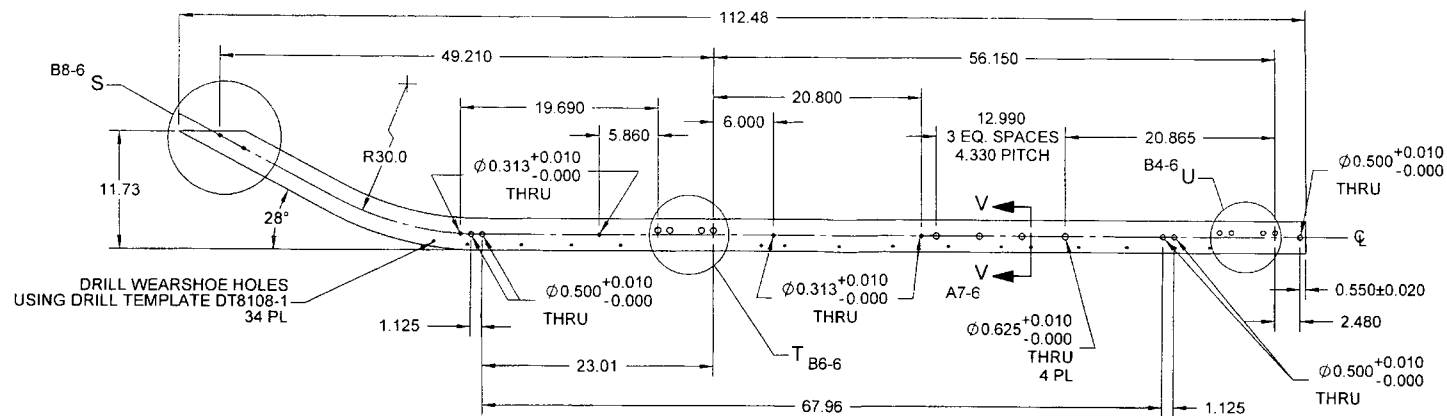
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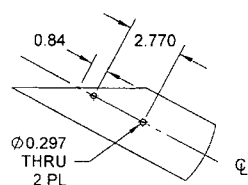
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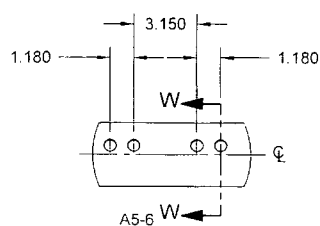
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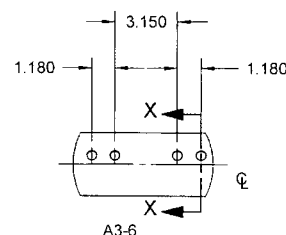
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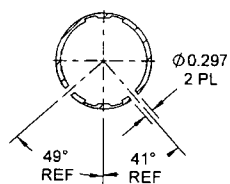
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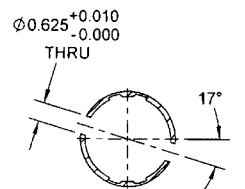
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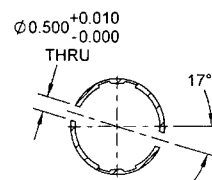
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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DESIGN		<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		D2750	SHEET 6 OF 11
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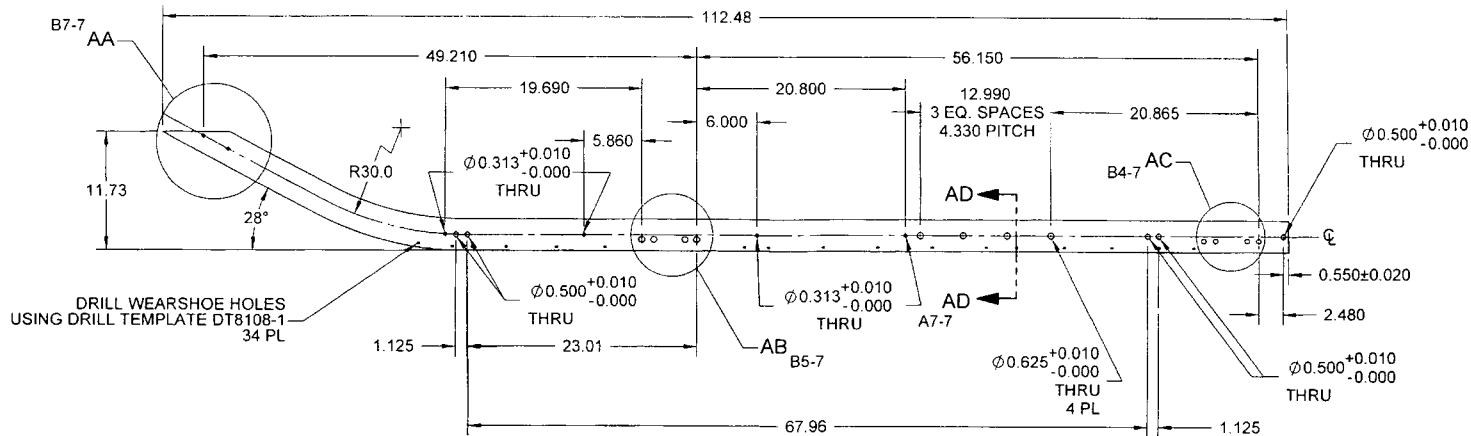
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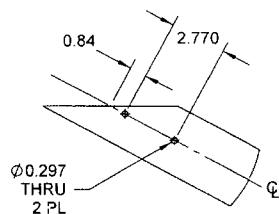
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

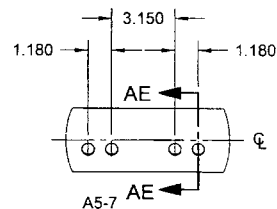
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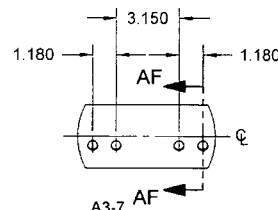
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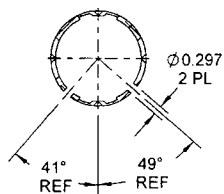
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SCALE 2X



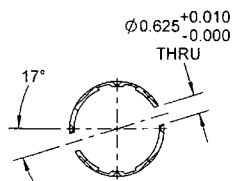
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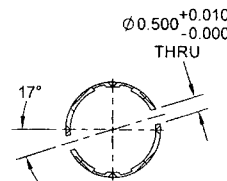
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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06-09-22-110

DESIGN	PAH	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	PAH	DRAWING NO.	REV. F
MFG. APPR.	PAH	D2750	SHEET 7 OF 11
APPROVED	PAH	TITLE	SCALE
DE APPR.	PAH	<b>350 SKIDTUBE ASSEMBLY</b>	
DATE	08.07.16	NTS	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

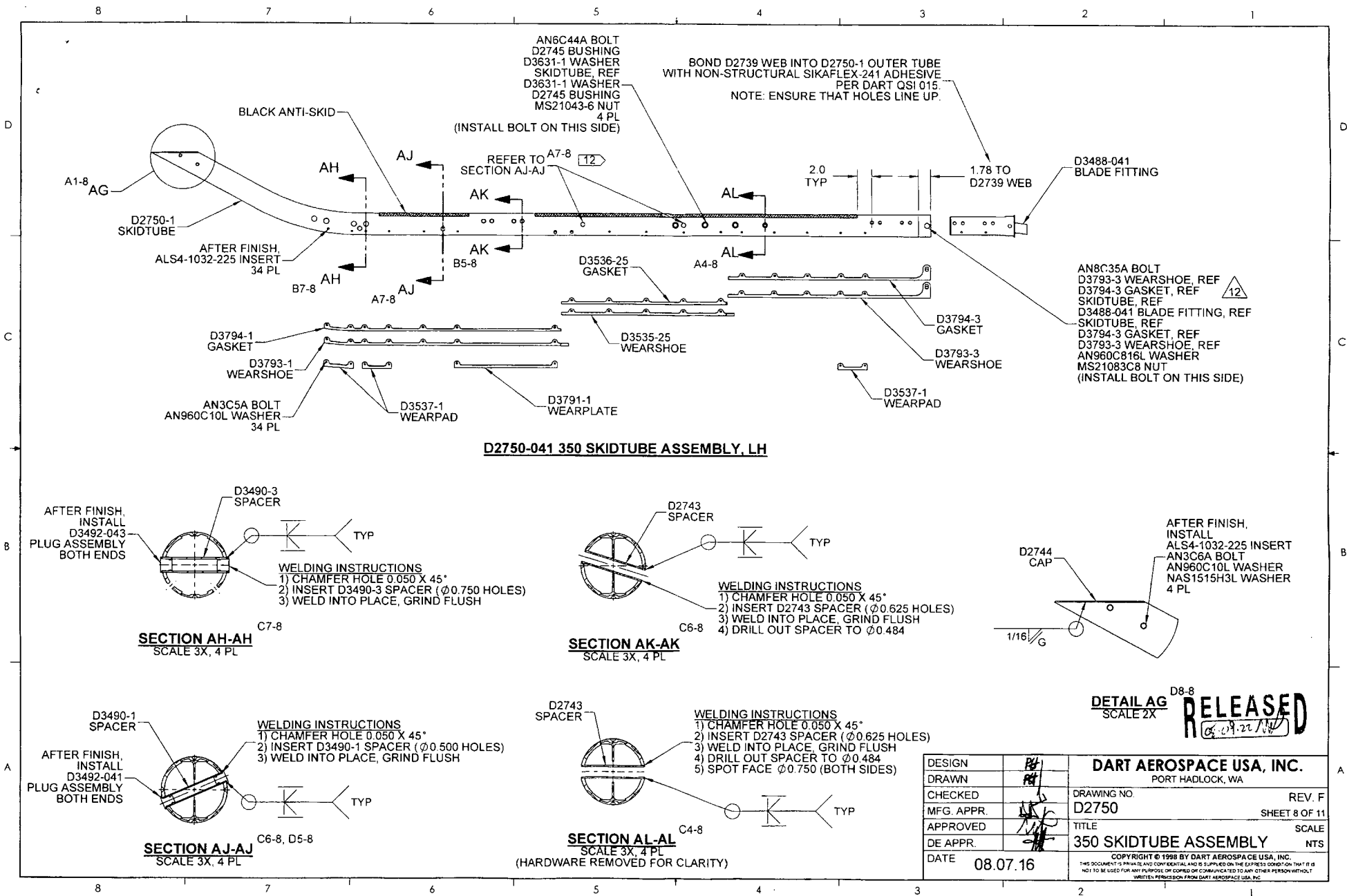
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DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 8 OF 11
APPROVED		TITLE	SCALE
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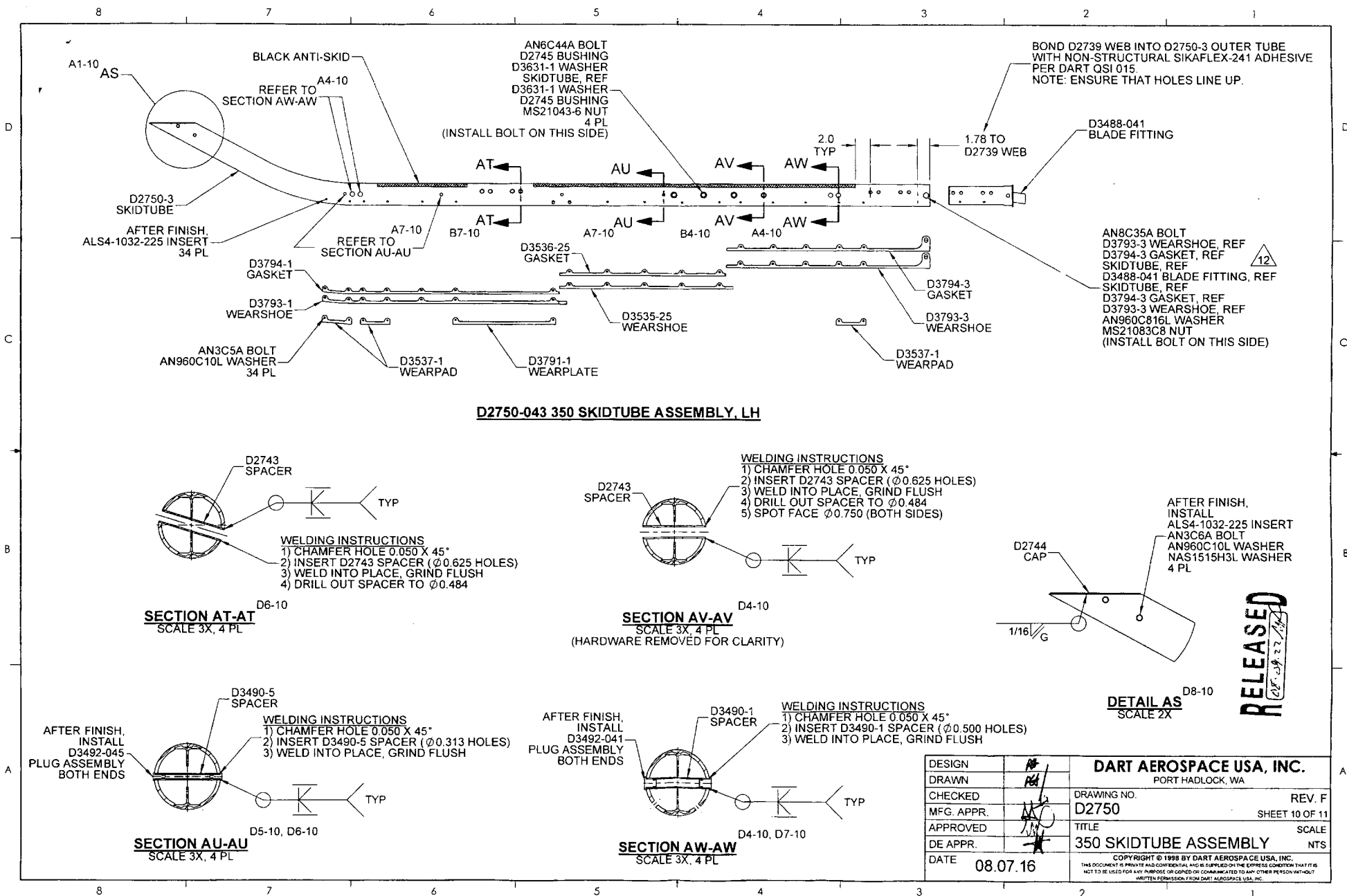
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 10 OF 11
APPROVED		TITLE	SCALE
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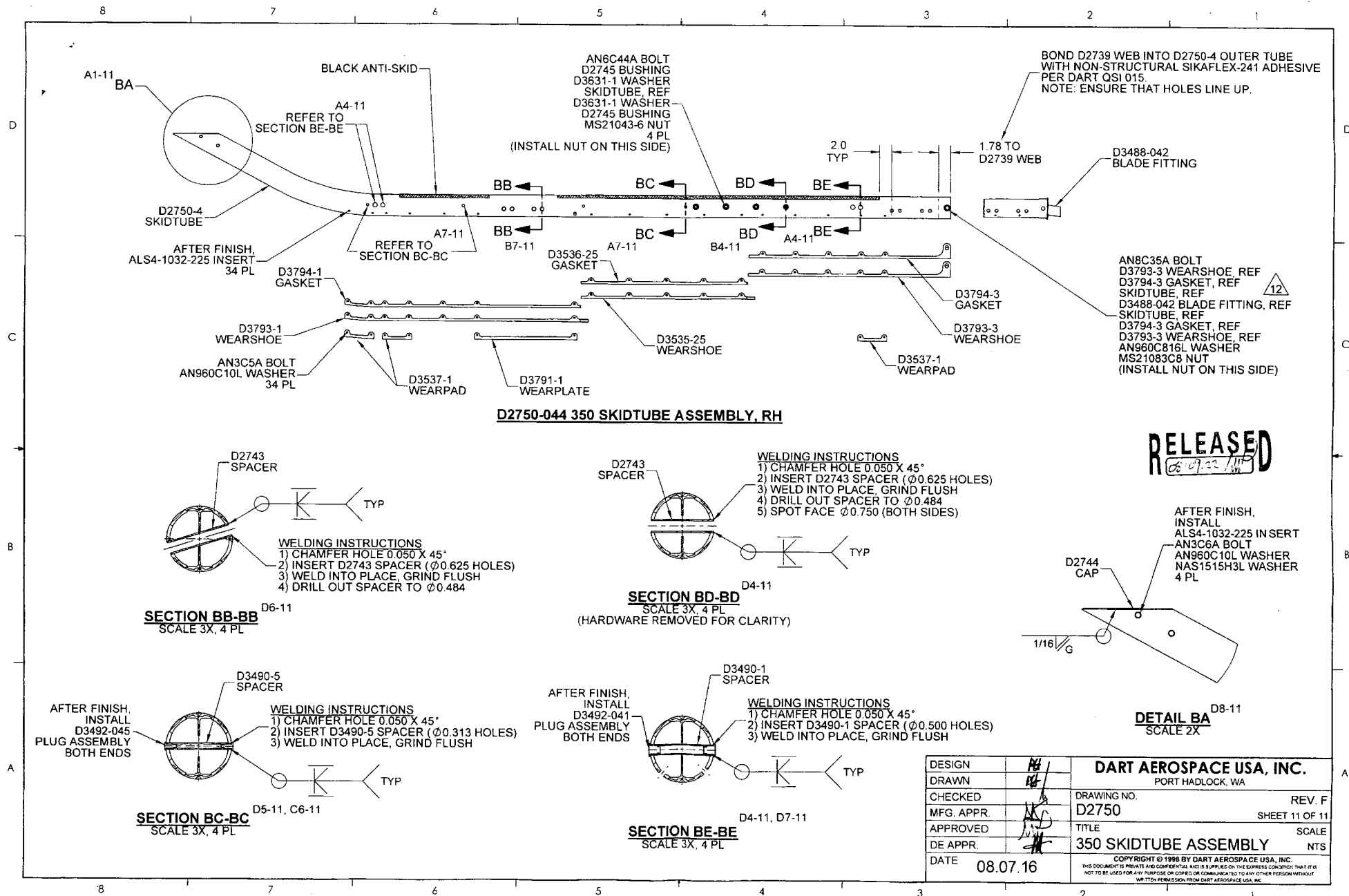
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



NO. 300

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job #: 87941  
Part #: D350-636-011  
Description: Seal  
Welding Process: Tig[ ☒ ] Mig[ ]  
Base material: Alum.  
Current: AC[ ☒ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Penetration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Fusion:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Cracks:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Overlap (cold lap)	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Undercut:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Pin holes:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Porosity (surface):	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Coloration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Burn through:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]

Qualifier David David Date of Test Coupon 12.07.20  
Welder Barclay Elliott Date of Test Coupon 12-07-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld